

Date: Monday, 27/10/2008 7:49:13 AM  
 User: Jean-Luc Menard

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SUPPORT
Job Number	: 42968		
Estimate Number	: 12487		
P.O. Number	:	Part Number	: D35021
This Issue	: 27/10/2008 S.O. No. :	Drawing Number	: D3502 REV.B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 1/1 Type : MACHINED PARTS	Drawing Revision	: B
Previous Run	: 41603	Material	:
Written By	: <u>08.10.27</u>	Due Date	: 03/11/2008 Qty: 30 Um: Each
Checked & Approved By	:		
Comment	: Est Rev:A New Issue 06-07-06 JLM Est Rev:B Add tooling hole 07-03-28		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M8061T6B1000X04000	6061-T6 Bar 1.00 x 4.00
-----	--------------------	-------------------------



Comment: Qty.: 0.3035 f(s)/Unit Total : 9.1035 f(s)

6061-T6 Bar 1.0" x 4.0"

batch: M107221

ml 08/10/27

(30)

2.0	BAND SAW	BAND SAW
-----	----------	----------



Comment: BAND SAW

Cut blank 3.475" long

1 BLANK MAKES 2 PARTS

ml 08/10/27

(30)

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA649 Rev: B & Dwg D3502 Rev: B

2-Deburr per dwg D3502

H.A

08/10/27

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	----------------------------------------



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

H.A

08/10/27

5.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

RF 08/10/28

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT

Job Number: 42968

Part Number: D35021

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

6.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1  
Drill as per Dwg D3502.

FF 08/11/03

(30)

7.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
-----	-----------------	----------------------------



(30X)

Comment: HAND FINISHING RESOURCE #1  
Chemical Conversion Coat as per QSI 005 4.1

M-1

08/11/03

8.0	POWDER COATING	POWDER COATING
-----	----------------	----------------



(30X)

M 109152

Comment: POWDER COATING  
Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

12:50  
320 OF  
1:20

M-1

08/11/03

9.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
-----	-----	-----------------------------------------



44

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-11-03

(30X)

10.0	PACKAGING 1	PACKAGING RESOURCE #1
------	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

ST 106

85 08/11/04 (30)

11.0	QC21	FINAL INSPECTION/W/O RELEASE
------	------	------------------------------



08/11/05 44

Comment: FINAL INSPECTION/W/O RELEASE

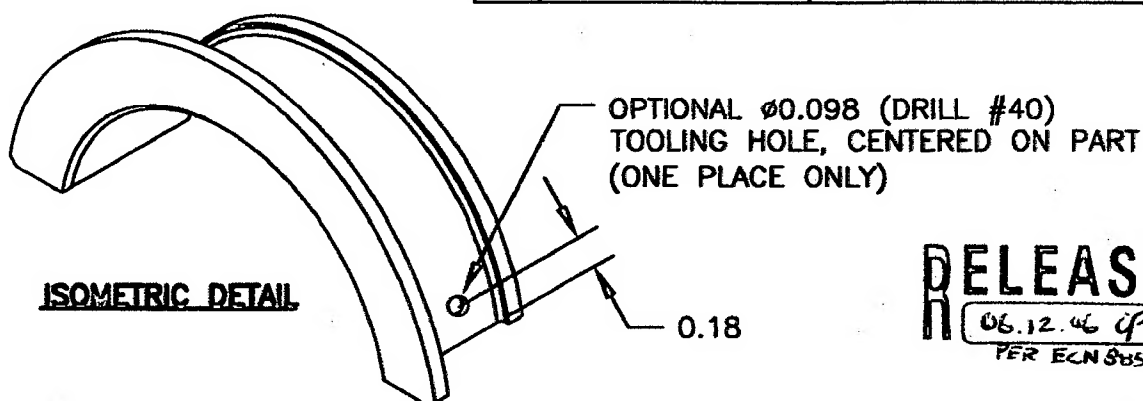
Job Completion



MF 08-11-04

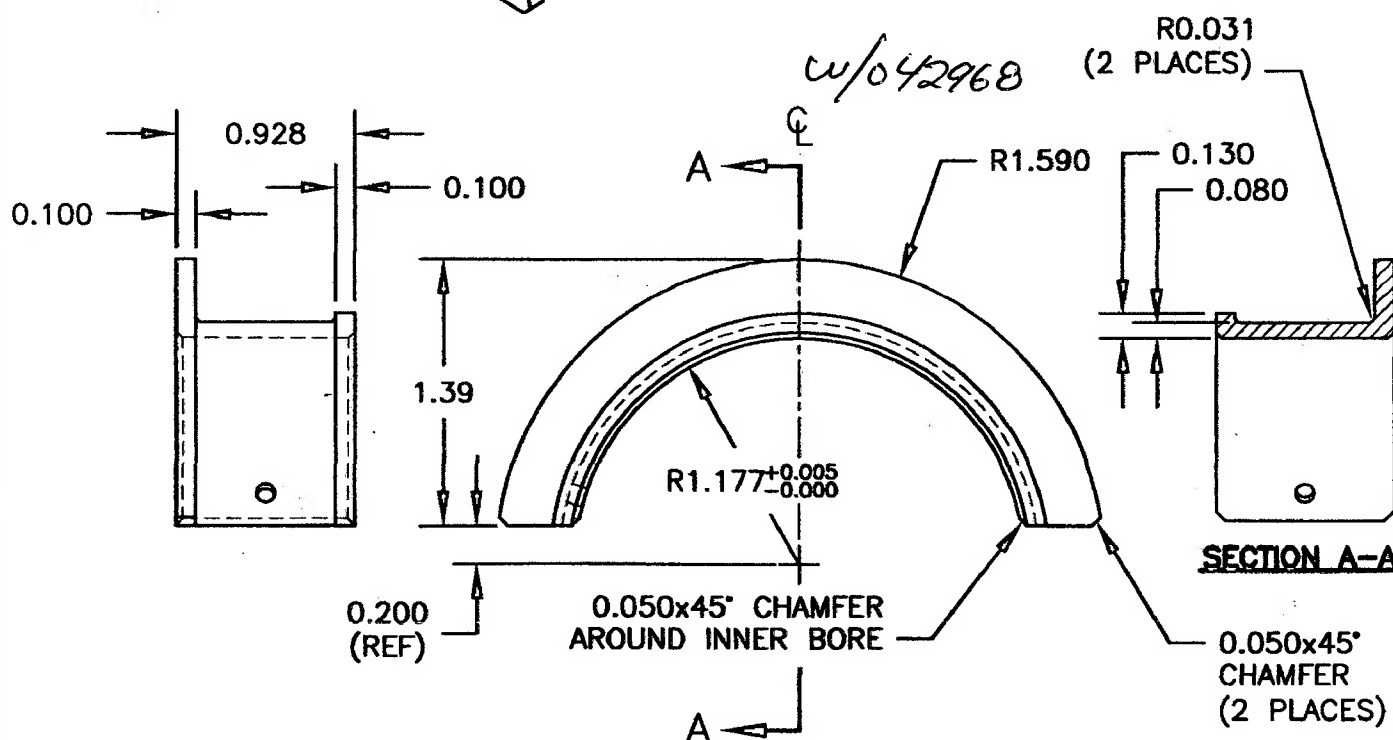


DESIGN <i>qp</i>	DRAWN BY <i>qp</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3502	REV. B SHEET 1 OF 1
DATE 06.10.31	TITLE SUPPORT		SCALE 1:1
A	06.04.18	NEW ISSUE	
B	06.10.31	ADD TOOLING HOLE FOR FINISHING	



ISOMETRIC DETAIL

RELEASED  
06.12.06 *qp*  
PER ECN 985



### D3502-1 SUPPORT

- 1) MATERIAL: 6061-T6 ROUND BAR (REF DART SPEC. M6061T6R)
- 2) BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 (REF. X.XXX =  $\pm 0.010$ , X.XX =  $\pm 0.030$ ) UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3

Copyright © 2006 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

